Work Orde May-27-13 12:4			188		*102	188*						Page 1
Item ID: Revision ID:	D3884-2	2			Accept	*N900	<b>040</b>	100	)* s	Setup Star	* *N	S1*
Item Name:	Saddle, I	nboard	RH							Sto	*N	S2*
Start Date:	5/21/13		<b>Start Qty:</b> 12.00	*12*		Cust Item II	<b>D:</b>					
Required Date: Reference:	5/27/13		<b>Req'd Qty:</b> 12.00	*12*		Customer:	ਜੰ - 			,		
Approvals:	Proces	s Plan	: M/5	Date:/3-05-30	Tooling:	Da	te:		R	Run Stai	1/1	R1*
QC:					SPC (Y/N):					Sto	*N	R2*
Sequence ID/ Work Center II	D		Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr		Revi	sion Nbr									
D3884		В										
*100  *100*  HAAS I  HAAS CNC vertica	l machine :		HAAS CNC VERTICAL  Memo Program Bat	MACHINING #1	0.00	A BloH	X		_)2			
		, <u>-</u>	Double chec 1-Machine S Sheets 2-Machine S Sheets		and inspect per attached	Dimension				·		
*110 *110*			QC2- Inspect parts off m	achine FAI/FAIB	0.00	rR 13/07/0	6.		12	B		
QC			Memo		0.00				100		· ———	

Quality Control

											DQA:	Dat	e:
NCR: Y	'es	/ No				WORK ORDER NON-C	O	NFOR!	MANCE / UPDATE		QA Closed:	Dat	e:
						DISPOSITION			AGAIN	IST DE	PARTMENT	<del> </del>	
Work Orde	er: _					Rework	1		Skid-tube Crosstu	he		Water Jet	Engineering
Part N	lo.					Scrap			Machining Small F		Pro	d. Eng. Coor.	Quality
	•					Use-as-is	]		noforming Finish	~ —	Rec/Sto	re/Packaging	Other
NCR N	۱o					Work Order Update	}		Large Fab Compos	ite	İ	Supplier	
Root					Descri	ption of work order update		Initial	Action		Sign &		
Cause		Date	Step	Qty		or Non-conformance	Cł	nief Eng	Description		Date	Verification	QC Inspector
Doc/Data													
Equip/Tooling							İ						
Operator	Ц					•							
Material			İ				1						
Setup					1		ļ						
Other											1	ĺ	
Process	Ш		ŀ								<u> </u>		
Supplier	Ш												
Training	Ш				Ì								
Unapproved			<u> </u>	<u> </u>	<u> </u>		<u> </u>				<u> </u>	<u> </u>	
							AUI	LT CATE	GORY				
Landi					_	General		٦			1	ſ	——————————————————————————————————————
	Ш	Bending			<u> </u>	Bend	$\vdash$	Grain			Ovalized		Pressure/Forced
	Ш	Centre N	ot Conce	ntric to	O/S	BOM/Route	_	Hardwa		_	Over/Under		Temperature/Cure
	$\vdash$	Cracks				Broken/Damaged	$\vdash$	<b>⊣</b> `	ion Incomplete		Part Incorre	ŀ	Weld
		Crushed/	'Crimped			Burrs	$\perp$	-1	tions Incomplete/Unclear		Part Lost/M	- L	Wrong Stock Pulled
		Cuffs				Contamination		Mainte			Part Moved		
		Heat Tre	at			Countersink	1	Mislabe	eled	- [	Positioned \	Vrong	

Misread Offset

Out of Calibration

Out of Sequence

Outside Dimensions

Power Loss/Surge

Other

Ripples in Bend

Turning Sequence

Wave/Twist in Tube

Inspection Strip in Tube

Torque Waves in Extrusion

Cut Too Short

Drill Holes Drawing

Finish

Folio

		•				
	K 7	t m	$\sim$	er ID	4 A	<b>~</b> 4 0 0
•	4/2	140 7			111	.,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,
w	V 4 I	I P' IK				/. I AA

Page 2

May-27-13 12:40:59 PM

Required Date: 5/27/13

	ID:	

D3884-2

5/21/13

Accept

\*N900040100\*

Setup Start \*NS1\*

\*NC2\*

Revision ID:

Item Name:

Start Date:

Saddle, Inboard RH

**Start Oty: 12.00** 

Reg'd Oty: 12.00

\*12\*

**Cust Item ID:** 

**Customer:** 

Reference:

Approvals:

Process Plan: \_\_\_\_ Date: Tooling:

QC: Date: SPC (Y/N):

Date:

Date:

Tool # Plan

Code

Reject

Otv

Stop

Number Stamp

Insp.

Sequence ID/ Work Center ID

120

\*120\*

Operation Description

OC8- Inspect parts - second check

Memo

0.00

Set Up/

**Run Hours** 

13/07/08

Tool ID

12 Ø

Accept

**Qty** 

Run

Reject

**Ouality Control** 

\*120\* HandFinish

Hand Finishing

Chemical Conversion Coat per OSI005 4.1

0.00

Memo

0.00

12 7613.79

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

\*110\* Powdercoat

Powder Coating

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

730

0.00

7730

1.00

1.00

12 xp m-/13/07/09

m125620

												DQA:	Da	ite:	
NCR:	Yes	/ No				WORK ORDER NON-	COF	<b>NFORM</b>	ANCE / UP	DATE		·			
										" <u></u>		QA Closed:	Da	ite:	
Work Orde	o ż.					DISPOSITION				AGAINST D	EF	PARTMENT	PROCESS		
Work Ordi	ei.	•				Rework	1		Skid-tube	Crosstube	٦		Water Jet		Engineering
Part f	No.					Scrap	1		Machining	Small Fab		Pro	d. Eng. Coor.	$\vdash$	Quality
						Use-as-is	1		noforming	Finishing	┪		e/Packaging	1	Other
NCR I	No.					Work Order Update	1		Large Fab	Composite			Supplier		
Root						ption of work order update	1	Initial		tion		Sign &		i	
Cause		Date	Step	Qty	•	or Non-conformance	Ch	nief Eng	Desc	ription		Date	Verificatio	n	QC Inspector
Doc/Data	Ш														
Equip/Tooling															
Operator															
Material			ļ												
Setup	L							,			ı				
Other								. £							
Process															
Supplier							1								
Training	L						İ								
Unapproved			<u> </u>	<u> </u>	ļ	· · <del>- · · · · · · · · · · · · · · · · ·</del>	<u> </u>						<u> </u>		
							AUI	LT CATE	GORY				· · · · · · · · · · · · · · · · · · ·		
Land	ing (	1				General	_	<b>7</b>		г		1		r	1
	_	Bending				Bend	<u> </u>	Grain		-	_	Ovalized		$\vdash$	Pressure/Forced
		Centre N	ot Conce	ntric to	o/s  _	BOM/Route	<u> </u>	Hardwa		_		Over/Under		-	Temperature/Cure
		Cracks			<u> </u>	Broken/Damaged	<b></b>	- '	ion Incomplete			Part Incorred		-	Weld
	$\perp$	Crushed,	'Crimped			Burrs	$\perp$	-1	ions Incomplete/	Unclear		Part Lost/Mi	issing	<u></u>	Wrong Stock Pulled
	$\vdash$	Cuffs				Contamination	$\vdash$	Mainte				Part Moved			
	$\perp$	Heat Tre	at		_	Countersink	$\perp$	Mislabe		-		Positioned V	_		1
	1	Inspection	n Strip in	Tube	1	Cut Too Short	ĺ	Misrea	d .	i		Power Loss/	Surge	1	Other

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

Drill Holes Drawing

Finish

Folio

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Torque Waves in Extrusion

- 1	rk Ord		02188	<u> </u>	*102	2188*	:····			;;;;;;;;;;;;;;;;;;;;;;;;;;;;;;;;;;;;;;	<u> </u>		Page 3
Item Rev	ID: ision ID: Name:	D3884-2 Saddle, Inb	oard RH		Accept	*N9000	140	100	)*	Setup	Start Stop	*N:	S1* S2*
Req	t Date: uired Date: erence:	5/21/13 : 5/27/13	<b>Start Qty:</b> 12.00 <b>Req'd Qty:</b> 12.00	*12* *12*		Cust Item ID Customer:	) <b>:</b>				·		
App	rovals:	Process I	Plan:	Date:	Tooling: SPC (Y/N):	Dat	e:			Run	Start Stop	*N  *N	R1* R2*
Woi 150 *1	uence ID/ rk Center I	D ·	Operation Description QC3- Inspect Part Finish		Set Up/ Run Hours 0.00	Tool ID	Tool#	Plan Code	Accept Qty	Rej Qty	, ]	Reject Number 37-	Insp. Stamp
	ity Control		Memo									7	
160 * <b>1</b> Pack	And the caging aging		Identify as per dwg & Stoo Memo	Sty3/A	0.00					<u> </u>	13/	17/1°	0 (12
170 <b>*1</b> QC	<b>7</b> 0*		QC21- Final Inspection - \	Work Order Release	0.00			·		13	11/1	10	1

Quality Control

13/1/10 8

NCR:	Yes	1	No

DQA: Date:

NCR: Ye	s / No				WORK ORDER NON-C	ONFOR	MANCE / U	PDATE	QA Closed:	Date:	
Work Order	•	_ ;			DISPOSITION			AGAINST DE	PARTMENT	PROCESS	
Part No					Rework Scrap		Skid-tube Machining	Crosstube Small Fab	4	Water Jet d. Eng. Coor.	Engineering Quality
NCR No	o				Use-as-is Work Order Update	Ther	moforming Large Fab	Finishing Composite	Rec/Stor	e/Packaging Supplier	Other
Root				Descri	ption of work order update	Initial	<i>I</i>	Action	Sign &		
Cause	Date	Step	Qty	(	or Non-conformance	Chief En	g De:	scription	Date	Verification	QC Inspector
Doc/Data											
quip/Tooling	_										
Operator	_						1				
Material	4						Ì				
etup	4										
Other	_		]			·					
Process	_					1					
Supplier	_										
Fraining		1									
Jnapproved		<u> </u>			F	AULT CAT	EGORY				
Landin	g Gear				General				· · · · · ·		
Γ	Bending		•	Γ	Bend	Grain			Ovalized		Pressure/Forced
F	Centre N	ot Conce	ntric to	o/s	BOM/Route	Hardv	vare		Over/Under	tolerance	Temperature/Cure
F	Cracks				Broken/Damaged	Inspe	ction Incomplete		Part Incorre	ct	Weld
	Crushed/	'Crimped			Burrs	Instru	ctions Incomplet	e/Unclear	Part Lost/Mi	ssing	Wrong Stock Pulled
	Cuffs	-			Contamination	Main	tenance		Part Moved	_	
	Heat Trea	at			Countersink	Misla	peled		Positioned V	Vrong	_
ļ	Inspectio	n Strip in	Tube		Cut Too Short	Misre	ad		Power Loss/	Surge	Other
Ţ	Ripples in	n Bend			Drill Holes	Offset	t				
	Torque V	Vaves in I	Extrusio	n [	Drawing	Out o	f Calibration			-	-
	Turning S	Sequence	<b>!</b>		Finish	Out o	f Sequence				
	Wave/Tv	vist in Tu	be		Folio	Outsi	de Dimensions				

May-27-13 12:40:58 PM

Work Order ID:

102188

Parent Item:

D3884-2

Parent Item Name:

Saddle, Inboard RH

**Start Date: 5/21/13** 

Required Date: 5/27/13

**Start Oty: 12.00** 

Required Qty: 12.00

Comments:

IPP RevA: New issue DD verified by:EC

	-	<u> </u>	
	1	·	
ì	Con	ponent Item ID/	
	100	-,	
	Item	Name	
į.	11011	Manie	
		T.	

Replacement. Item ID

Mfg/ Purch Bin **Primary** Item Location

Last Location

Route Seq ID

Unit of Measure Hand

Qty on

Qty per Kit Total

Qty Issued

Date Status

D6101-017

Manufactured

No

Each 11.0000 Qty

Issued

Saddle Billet

Location MAT040

Loc Qty 11 Loc Code

94444

11

B102959 X/2

ont 13/07/06

12

											DQA:	Date	:
NCR: Y	es/	/ No				WORK ORDER NON-	COI	NFORM	MANCE / UP	DATE	QA Closed:	Date	· :
Work Orde	· ·					DISPOSITION				AGAINST D	EPARTMENT	/PROCESS	
Part N	lo.					Rework Scrap Use-as-is Work Order Update		Therm	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite		Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root					Descri	ption of work order update		Initial	Ac	tion	Sign &		
Cause		Date	Step	Qty	(	or Non-conformance	Ch	nief Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved		,						•					
						F	AUI	LT CATE	GORY				
Landi		1			_	General		7	•	_	_		<b>-</b> .
		Bending Centre N	ot Conce	ntric to (	o/s	Bend BOM/Route		Grain Hardwa			Ovalized Over/Under	<u> </u>	Pressure/Forced Temperature/Cure Weld
	$\vdash$	Cracks Crushed/	Crimped			Broken/Damaged Burrs	E	Instruct	ion Incomplete ions Incomplete/	'Unclear	Part Incorre	issing	Wrong Stock Pulled
		Cuffs Heat Trea				Countersink		Mainte Mislabe	eled	-	Part Moved Positioned	Wrong	<b>7</b>
	H	Inspectio	-	1 Tube	-	Cut Too Short Drill Holes	$\vdash$	Misread	j	L	Power Loss,	/Surge	Other

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence
Wave/Twist in Tube

Torque Waves in Extrusion

Drawing Finish

Folio

DART AEROSPACE LTD	Work Order:	102188
	Sy.	
Description: Saddle, Inboard, RH	Part Number:	D3884-2
Inspection Dwg: D3884 Rev. B		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing and record below:

				Re					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	Ву	Date
Α	2.870	2.880		2.876	2.875	3.875	3,875		
В	1.433	1.443		1.437	1.438	1.438	1. 438		
С	0.638	0.658		3.898	648	.648	.648		
D	3.895	3.905		3.898	3.899	3.899	3.899		
E	0.257	0.262		.259	.259	.259	.259		
F	0.605	0.625		. 614	-615	.615	.415		
G	1.120	1.130		1.124	1.125	1.125	1,125		
Н	2.245	2.255		2,250	2.250	2.250	2,250		
ļ	2.000	2.020		2,0035	2.005	2005	2.005		
J	0.140	0.175		152	152	.152	.150		4-
K	1.265	1.285		1.269	1.269	1.269	1.269		
L	0.115	0.135	ia.	,127	127	127	.127		
M	0.240	0.260		.257	257	, 257	1,257		
N	0.110	0.140		.140	.140	.140	.140		
0	0.240	0.260		.249	249	.249	.250		
Р	2.826	2.886	,	2.866	2.866	2.866	2,866		**, * *
Q	0.178	0.198		. 188	. 188	. 188	.188		· a
R	0.140	0.165		.158	.158	.152	156		
S	0.720	0.780		.765	745	745	,705		
T	1.220	1.280		1.260	1.260	1.210	1.260		
U	1.245	1.255		1.250	1.250	1.250	1.250		
V	5.990	6.010		6.601	6.001	6.001	1.001		
W	2.495	2.505		2,500	2.500	2,500	2.500		
X	0.490	0.510		,5015	.501	.500	· <b>S</b> D D		
Υ	0.020	0.040		.030	.030	.030	.030		
Z	0.313	0.318		.314	.315	,3/5	.315		
AA	0.760	0.765		.760	760	,740	7/0		
AB	0.215	0.220		,219	.219	.219	.219		
AC	0.316	0.321		.317	.3/7	.3/7	.3/7		
AD	1.745	1.755		1.750	1.750	1,750	1.750		
AE	0.990	1.010		1.000	1.000	1.000	1.000		
AF									
	Acc	ept/Reje	ct				DAS.		

Measured by:	Audited by 9-89
Date: 13/07/06	Date: 13/07/08

Rev	Date	Change	Revised	<b>фу</b> ∐	Appro	ved
Α	09.10.22	New Issue	KJ 🛠	710		7
				7		

DART AEROSPACE LTD	Work Order:	102188
>		
Description: Saddle, Inboard, RH	Part Number:	D3884-2
Inspection Dwg: D3884 Rev. B		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing and record below:

		-		Red	corded Actu	ual Dimensi	ons		
Dim	Min	Max	Go/No Go Gauge	1/5	Zle	87	AB	Ву	Date
Α	2.870	2.880		2.875	2.875	2.875	2.875		
В	1.433	1.443		1.438	1.438	1.438	1.438		:
С	0.638	0.658		648	.648	. 648	.648		
D	3.895	3.905		3.900	3.900	3.900	3.900		
E	0.257	0.262		.259	,259	.258	.258		
F	0.605	0.625		615	1615	1.615	1115		
G	1.120	1.130		1.125	1.125	1.125	1.125		
Н	2.245	2.255		2.250	2,250	2,250	2.250		
ı	2.000	2.020		2004	2.004	2,004	2.004		
J	0.140	0.175		154	.153	1.152	1152		·- 4-
K	1.265	1.285		1.2109	1.269	1.2685	1.2695	-	
L	0.115	0.135		ノダフ	127	1127	127		
М	0.240	0.260		.251	. 257	.251	.257		
N	0.110	0.140		.140	.140	.140	140		
0	0.240	0.260		.248	.249	,250	,249		
Р	2.826	2.886		2.866	2.866	2.866	2.866		· ·
Q	0.178	0.198		188	188	.188	.188		`@
R	0.140	0.165		156	157	157	157		
S	0.720	0.780		7/25	71.5	1765	1745	-	
T	1.220	1.280		1,240	1.260	1.240	1.250		
U	1.245	1.255		1.250	1,250	1,250	1,250		
V	5.990	6.010		1.001	6.001	6.001	4-001		
W	2.495	2.505		2,500	2.500	2.50h	2.500		
X	0.490	0.510		.500	.500	.500	·50D		
Υ	0.020	0.040		· 030	, b3b	. p3t	.030		
Z	0.313	0.318		.315	. 315	.315	. 3/5		
AA	0.760	0.765		.760	.760	760	740		<del></del>
AB	0.215	0.220		.219	.219	.219	.219		
AC	0.316	0.321		.3/7	,317	3/7	. 3/2		
AD	1.745	1.755		1.750	1.750	1.75	1.750		
AE	0.990	1.010		1. bbh	1.000	1.000	1.000		.,
AF									_
	Acc	ept/Reje	ct				OAS		

Me	asured by:	And		Audited by	-4	<u>4</u>				
	Date:	13/07/06		Date:	13/	FO	80			
Rev	Date	Change				Re	evised by	y   /	3ppro	Next
Α	09.10.22	New Issue	1			K		- (		//

DART AEROSPACE LTD	Work Order:	102188
Description: Saddle, Inboard, RH	Part Number:	D3884-2
Inspection Dwg: D3884 Rev. B		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing and record below:

				Re	corded Actu	ual Dimensi	ons		
Dim	Min	Max	Go/No Go Gauge	19	210	811	9/12	Ву	Date
A	2.870	2.880		2.875	2.875	2.875	2.875		
В	1.433	1.443		1.438	1.438	1.438	1.438		
Ç	0.638	0.658		.648	. 648	.648	1,48		
D	3.895	3.905		3.9nD	3.900	3.900	3,900		
E	0.257	0.262		.259	,259	.259	,250		
F	0.605	0.625		.615	.415	.615	.615		
G	1.120	1.130		1.125	1.125	1.125	1.125		
Н	2.245	2.255		2.250	2350	2.350	2.250		
l l	2.000	2.020		2,004	2,004	2.604	2004		
J	0.140	0.175		.153	1.152	1152	153		4*
K	1.265	1.285		1.2695	1.269	1,2695	1.269		
L	0.115	0.135		127	127	1127	127		
M	0.240	0.260		.257	.257	. 257	.251		
N	0.110	0.140		.140	.140	. 140	.140		
0	0.240	0.260		.249	249	.249	,249		
Р	2.826	2.886	,	2.866	2.866	2.866	2.866		,
Q	0.178	0.198		1138	188	.188	.188		* O:
R	0.140	0.165		1.156	157	.158	.158		
S	0.720	0.780		.765	765	,71,5	.765		
Т	1.220	1.280		1.21ch	1.260	1.21.6	1.260		7
U	1.245	1.255		1.250	1.250	1.250	1.250		7
V	5.990	6.010		6.001	6.001	6.601	6.001		
V	2.495	2.505	,	2.500	2,500	2.500	2,500		
Χ	0.490	0.510		.500	.500	.500	.500		
Υ	0.020	0.040		.030	. b3D	.030	.030		
Z	0.313	0.318		.315	.315	.315	. 3/5		
· AA	0.760	0.765		,740	760	.760	760		
AB	0.215	0.220		.219	219	.219	.219		
AC	0.316	0.321		1.319	.3/7	-317	.317		
AD	1.745	1.755		1.750	1.750	1.750	1.750		
AE	0.990	1.010		1. DDD	1.000	1.000	1.000		
AF									
	Acc	ept/Reje	ct				DAS,		

Me	asured by:	CM.	Audited by 9-89
	Date:	13/07/07	Date: \3/07/08
Rev	Date	Change	Revised by Approved
Α	09.10.22	New Issue	KJ * (///

B 0.140 0.110 TYP 0.648 3.900±0.005 B BORE 0.615 Ø0.257<sup>+0.005</sup><sub>-0.000</sub> 6 PL 1.438±0.005 2.875±0.005 1.125±0.005 2.250±0.005 GRAIN DIRECTION R0.50 0.175 0.175 0.140 B 0.853 81.1 0.896 REF BORE Q SECTION D-D B6-1 D-2.08 REF B7-1

102188 MLJ 13-05-30-R2.000<sup>+0.020</sup><sub>-0.000</sub> R0.50 -0.050 x 45° CHAMFER TYP R0.50 C3-2 **DETAIL C** B2-2

 $\sim 62 \, \mathrm{Y}$ :1...1

D3884-1 SADDLE, INBOARD LH (SHOWN) D3884-2 SADDLE, INBOARD RH (OPPOSITE)

NOTES:
1) MATERIAL: 7075-T7351 ALUMINUM PER QQ-A-250/12 OR AMS-QQ-A-250/12 OR AMS-QQ-A-250/12 (REF DART SPEC. D6101-017)
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO
MAX. DEPTH OF 0.010 WITH A MIN. TOOL RAD OF R0.010

D6101-017 WAS D6102-017. ZN A6-1; ADD NOTE. ZN C4-2; ADD R0.031. ZN C2-2; INCREASED TOLERANCE 0.175 WAS 0.185. ZN B7-1; ADD 0.615, ZN C6-1. ADD 0.648, ZN C4-1; ADD 0.250. ZN D6-2; ADD 0.060. ZN C2-2; 0.75 WAS 0.65. ZN D7-2 09.06.30 Α NEW ISSUE RF 09.03.30 REV. DESCRIPTION BY DATE DART AEROSPACE USA, INC. DESIGN RF DRAWN RF CHECKED DRAWING NO. REV. B D3884 MFG. APPR. SHEET 1 OF 2 TITLE
INBOARD SADDLE

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